

Work Order ID 124130

124130

Page 1

September-11-14 11:55:38 AM

Item ID: D204-562-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Dual Mirror Installation
 Start Date: 8/27/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/10/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 14-09-12 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2161	B2
IIN-D212-580-1	B

ML5 15-01-20
3

100 Document Control 0.00
 100
 DC
 Doc.Control -USB or Paperwork
 Memo M.L.D.
 Photocopy bluefile & type labels per PPD204-562-041 CHG004
 3x DAS 46 JAN 20 2015

110 Pick Kit 0.00
 110
 Packaging
 Packaging
 Memo
 3x DAS 28 JAN 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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 Revision ID: Stop ***NS2***
 Item Name: Dual Mirror Installation
 Start Date: 8/27/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/10/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				(3x)	DAS 46 9-29		JAN 20 2015
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D204-562-041 Location: <u>FG010</u>	0.00 0.00				(3x)	DAS 46 9-29		JAN 20 2015
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

MLJ 15-01-21
 MUF
 15-1-21

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

September-11-14 11:55:37 AM

Page 1

Work Order ID: 124130

124130

Parent Item: D204-562-041

D204-562-041

Parent Item Name: Dual Mirror Installation

Start Date: 8/27/14

Required Date: 9/10/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed Manufacturing 05-11-01 JLM IPP REV:J
AS PER ECN 10-611 10-09-07 JLM VERIFIED
BY:DD IPP rev:K
10.11.22 AS PER ECN10-642 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3439-101 *D3439-101* Mirror Assembly 8"		Manufactured	No			110	Each	36.0000	2	76	DAS 28 9-89	JAN 2 0 2015	

DAS
46
9-89

Location	Loc Qty	Loc Code
FG	2	
103697	2	
ST381	34	
108921	6	
111611	7	
119044	19	
99854	2	

D2161-204 Manufactured No

D2161-204
Mirror Bracket
DAS
46
9-89

MS27039-1-08 Purchased No

MS27039-1-08
Screw

DAS
46
9-89

Location	Loc Qty	Loc Code
ST305	1874	
m123265	4	
m125654	3	
m128636	1867	

D2161-204	1	13	DAS 28 9-89
MS27039-1-08	4	412	DAS 28 9-89

119677

12

DQA: _____ Date: _____



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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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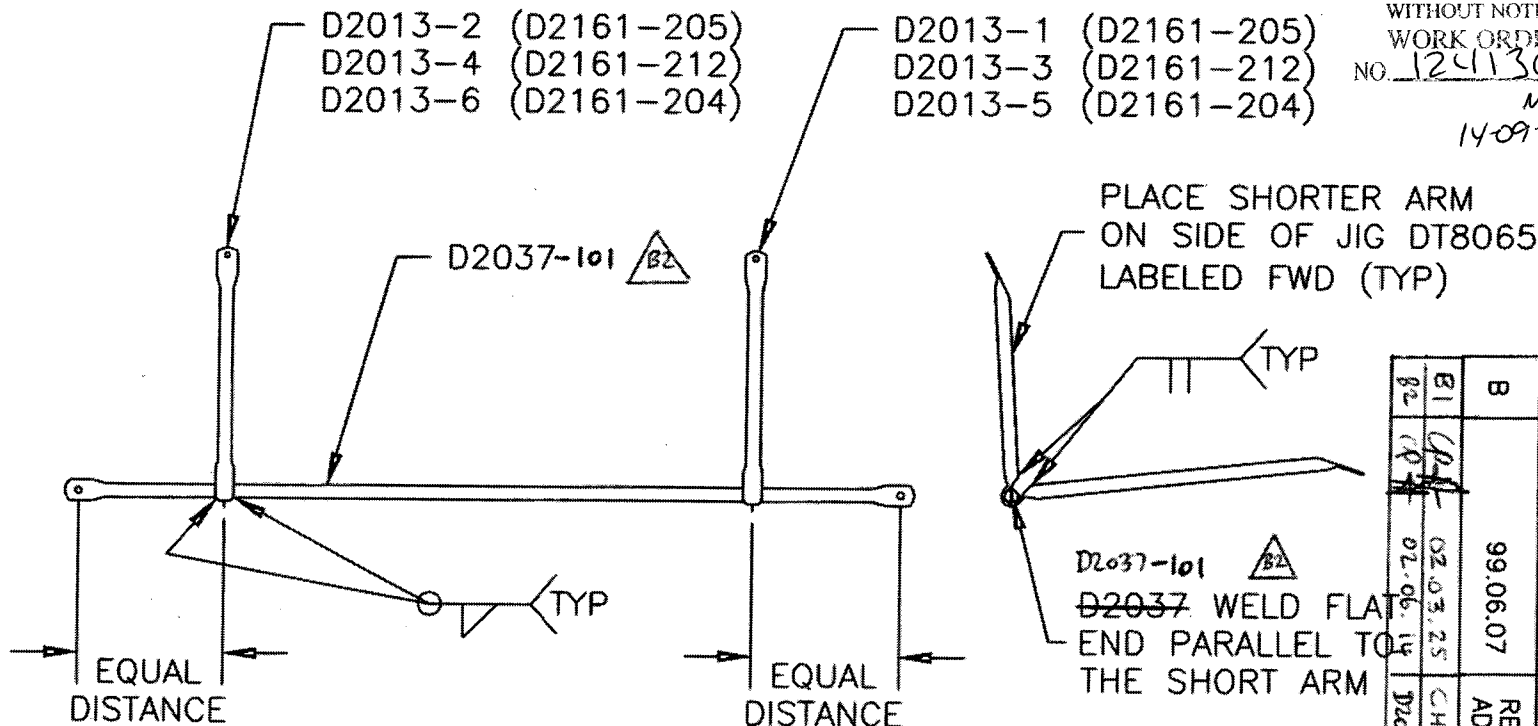
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WITHOUT NOTICE
WORK ORDER
NO. 124130

ML5
14-09-12



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DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3 (B)

DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	RT	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
4E	RT	D2161
DATE	TITLE	SHEET 1 OF 1
99.06.07	MIRROR BRACKET	SCALE
		NTS
A	93.04.29	NEW ISSUE
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS
B1	02.03.25	CHANGE FINISH
B2	02.06.14	D2037-101 WELD

RELEASED
4E 99.06.10